

Work Order ID 56570-2

Monday, March 01, 2010 2:58:38 PM

split



Page 1

Item ID: D3782-045

Accept



Setup Start



Revision ID:

Item Name: Back Leg Assembly

Stop



Start Date: 3/2/2010 Start Qty: 6.00

Required Date: 3/15/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 10-3-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3782

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ES 10/03/29 (4)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3782

ep

ES 10/06/01 (4)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ES 10/06/01

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56570**

Monday, March 01, 2010 2:58:38 PM



Page 2

Item ID: D3782-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Leg Assembly

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Identify as per dwg &amp; Stock Location:

248

0.00

Memo

0.00

10-6-2

40 SP

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/06/04 JF

W15.08.03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 01, 2010 2:58:38 PM

Page 1

Work Order ID: 56570



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec  
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C  
10.02.22 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3772-1		Manufactured	No			110	Each	3.0000	6.0000			
Back Leg												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

3

54374

3

D3787-1

Manufactured No



Foot

110

Each

36.0000

6.0000



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

11

46597

8

54337

3

Main Warehouse

ST249A

25

55763

25

D3764-1

Manufactured No



Back Leg Fitting

110

Each

16.0000

6.0000



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

16

51397

1

54340

15

*ES 10/06/01*  
*B 56860 (3x)*

*3*  
*ES 10/06/01*

*3*  
*ES 10/06/01*

*6*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, March 01, 2010 2:58:38 PM

Page 2

Work Order ID: 56570



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec  
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C  
10.02.22 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3773-041		Manufactured	No			110	Each	0.0000	6.0000			
					B56837							
Headrest Assembly												
D3786-1		Manufactured	No			110	Each	9.0000	6.0000			
Sleeve												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

9

44533

9

AN45-15A

Purchased

No

110

Each

27.0000

6.0000



EYE BOLT

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

27

109012

10

109091

12

109118

5

~~109091~~

Monday, March 01, 2010 2:58:38 PM

Shop Packet Print

Page 2



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 01, 2010 2:58:38 PM

Work Order ID: 56570



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec  
 IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C  
 10.02.22 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN5-15A		Purchased	No			110	Each	50.0000	6.0000			
Bolt												

*GP 3/10/03/29*

Warehouse	Loc	Qty	Loc Code
Location			
Main Warehouse			
ST		50	
108880		7	
110153		1	
111668		40	
14115		2	

6

AN5-17A		Purchased	No			110	Each	55.0000	6.0000			
Bolt												

Warehouse	Loc	Qty	Loc Code
Location			
Main Warehouse			
ST		55	
102140		4	
112314		1	
113538		50	

*GP 3/10/03/29*

6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, March 01, 2010 2:58:38 PM

Work Order ID: 56570



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ee  
 IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C  
 10.02.22 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-15A		Purchased	No			110	Each	179.0000	12.0000			
Bolt												

*Ep 10/03/29*  
*M 114239 (12)*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

179

113121

6

113538

23

113840

150

MS21042L4

Purchased

No

110

Each

1,965.000

12.0000



Nut

*Ep 10/03/20*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

1965

102552

6

104248

6

110507

184

111827

775

113422

994

15924

0

*12*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 01, 2010 2:58:38 PM

Page 5

Work Order ID: 56570



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec  
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C  
10.02.22 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L5		Purchased	No			110	Each	391.0000	18.0000			
Nut												

*Handwritten:* 9510/03/29

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

390

110382

10

111636

1

112314

16

113523

163

113537

200

*Handwritten:* 18

Main Warehouse

ST139

1

112314

1

*Handwritten:* QSI 017 NAS114900 4631 M113706

AN960JD416

Purchased

No

*Handwritten:* 24x



Washer

AN960JD516

Purchased

No



Washer

*Handwritten:* QSI 017

*Handwritten:* NAS114900 5631

*Handwritten:* M113524

*Handwritten:* 30x

0.0000



24.0000

0.0000



30.0000

*Handwritten:* 9510/03/29

*Handwritten:* 9510/03/29

Monday, March 01, 2010 2:58:38 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

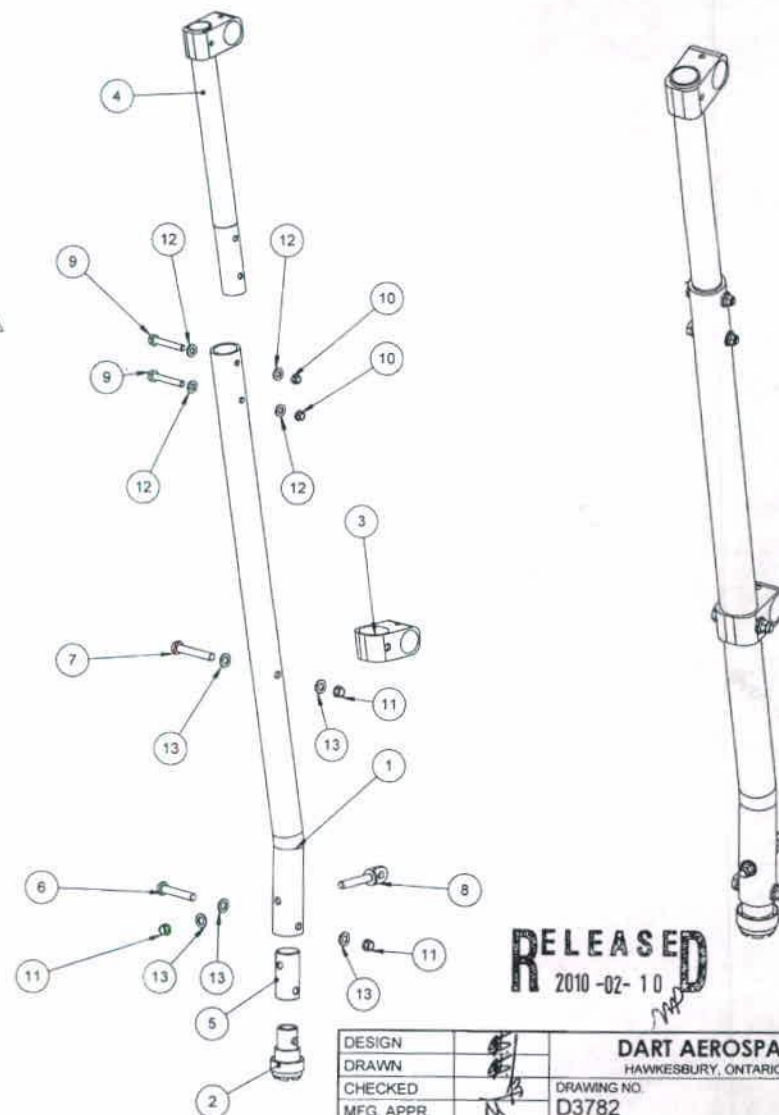
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

# **D3782-045 BACK LEG ASSY**



NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 4.71 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3782	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	NTS
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR THE DISSEMINATION OF INFORMATION WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries